Work Order ID 123120

Tuesday, July 29, 2014 2:31:07 PM

123120

Item ID: D4463-13 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Tank Bottom **Stop** *NS2*

Start Date: 7/29/14 **Start Qty:** 3.00 *3*

Required Date: 7/29/14 **Req'd Qty:** 3.00 *3*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** [signature] **Date:** 14.7.30 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / D4463	**Revision Nbr** / D								
100		0.00							DAS 23 9-89
100						3	0		14-11-05
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	Cut as per dwg								
60Ce1.063	Prog rev: P								
	Dwg rev: D								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 23 9-89
110						3	0		14-11-05
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							DAS 38 9-89
120						(3)			NOV 05 2014
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 123120

Tuesday, July 29, 2014 2:31:07 PM

123120

Item ID: D4463-13 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Tank Bottom

Start Date: 7/29/14 **Start Qty:** 3.00 *3*

Required Date: 7/29/14 **Req'd Qty:** 3.00 *3*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Bend as per dwg	0.00			DAS 30 9-89	3			14/11/10
130									
Brake NC	**Memo**	0.00							
Brake NC									
140	QC6- Inspect dimensions to drawing	0.00				(3)			DAS 38 9-89 NOV 10 2014
140									
QC	**Memo**	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00				3	0	14-11-12	DGC
150									
HandFinish	**Memo**	0.00							
Hand Finishing									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 123120

Tuesday, July 29, 2014 2:31:07 PM

123120

Item ID: D4463-13 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Tank Bottom **Stop** *NS2*

Start Date: 7/29/14 **Start Qty:** 3.00 *3*

Required Date: 7/29/14 **Req'd Qty:** 3.00 *3*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							DAS 38 9-89
160						3			
QC	**Memo**	0.00							
Quality Control									

NOV 13 2014

170	Identify as per dwg & Stock Location WA003	0.00							
170						3	DABS 9-89		
Packaging	**Memo**	0.00							
Packaging									

NOV 13 2014

180	QC21- Final Inspection - Work Order Release	0.00							
180							14/11/17		
QC	**Memo**	0.00							
Quality Control									

MF 14-11-14

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

Tuesday, July 29, 2014 2:31:06 PM

Work Order ID: 123120 *123120*

Parent Item: D4463-13 *D4463-13*

Parent Item Name: Tank Bottom

Start Date: 7/29/14 **Required Date:** 7/29/14

Start Qty: 3.00 **Required Qty:** 3.00

Comments: IPP REV:A 11.11.22 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	857.2880	2.748	~~8.677895~~			
M6061T6S.063									**	(9)		DAS 23 ~~9-89~~	14-11-05
6061-T6 .063 Sheet													

Location		Loc Qty	Loc Code	
MAT021		601.288		
	M124446	3.7		
	M126075	4.5		
	M127006	9		
	M127420	111.12		
	M128054	63.468		
	M128941	28		
	M129636	183		
	M129845	81.5		
	M129881	117		
TPI		256		
	M129637	256		

M130745

M130745

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

DART AEROSPACE LTD	Work Order:	123120
Description: Tank Bottom	Part Number:	D4463-13
Inspection Dwg: D4463 **Rev:** C		Page 1 of 1

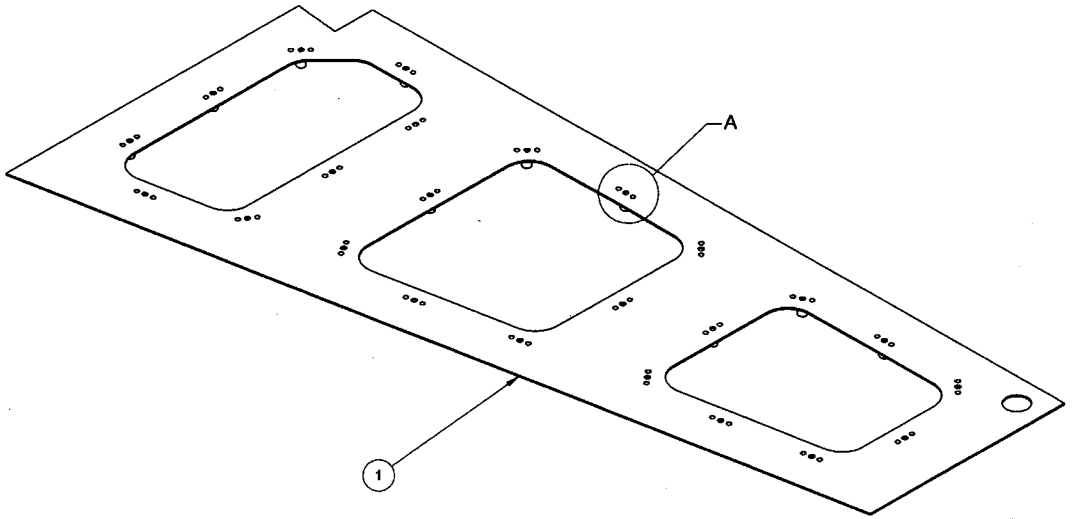
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
31.53	+/-0.030	31.53"	-		T	JKmo7
12.55	+/-0.030	12.55"	-		T	
32.03	+/-0.030	32.03"	-		T	
0.063	+/-0.010	0.063"	-		V	JKmo7
	DAS			DAS		

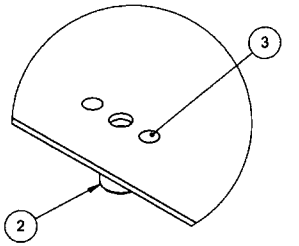
Measured by:	23 9-89	Audited by:	38 9-89	Preliminary Approval:	
Date:	14-11-05	Date:	NOV 05 2014	Date:	

Rev	Date	Change	Revised by	Approved
A	12.02.01	New Issue	KJ	
B	12.05.15	Dimensions updated per Dwg Rev C	KJ	

ITEM NO.	QTY -041	PART NUMBER	DESCRIPTION
	X	D4463-041	TANK TOP ASSEMBLY
1	1	D4463-1	TANK TOP
2	24	NAS1473-3	ANCHOR NUT
3	48	MS20426AD3-4	RIVET, CSK



D4463-041 TANK TOP ASSEMBLY



DETAIL A
24 PL

RELEASED
2014 -06- 11

J.A 14107130 123120

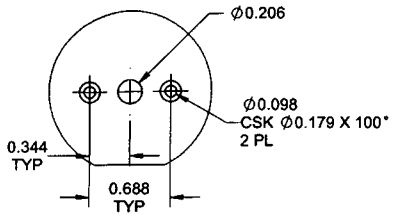
NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.77 lbs

REV.	DESCRIPTION	BY	DATE
D	ADDED RIVET PILOT HOLES TO D4463-9/-11 SHEET 9-12 REF NCR 13-3100 UPDATED D4463-3F (B3-4)	ML	14.05.13
C	ADD DIMS: ZN B5-5, D5-5, B2-11, B7-11, D3-11. ADD -13, MODIFY -1/-11.	DC	12.03.23
B	ADD D4463-041, ZN C5-1. UPDATED -1/-3/-5/-7/-9. COMBINED -11 & -13 INTO -11.	DC	11.12.14
A	NEW ISSUE	DC	11.10.19

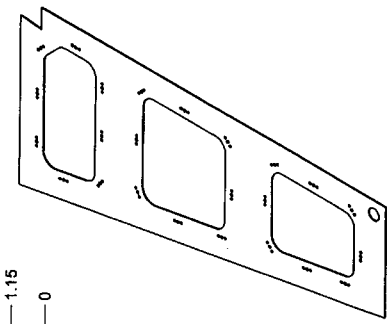
APPROVED

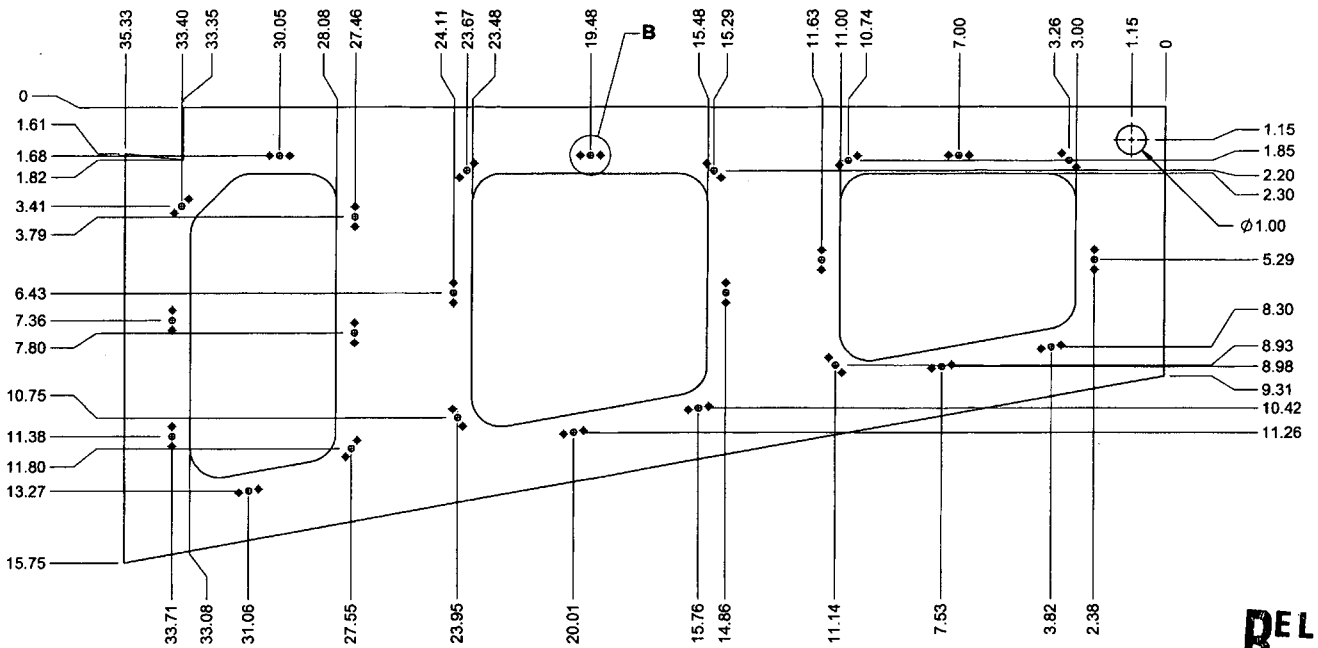
DESIGN	ML	DART AEROSPACE LTD
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	DRAWING NO. D4463 REV. D
MFG. APPR.	JLM	SHEET 1 OF 14
APPROVED	MP	TITLE AUX TANK SCALE NTS
DE APPR.	DS	
DATE	14.05.13	

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DETAIL B
(24 PL)





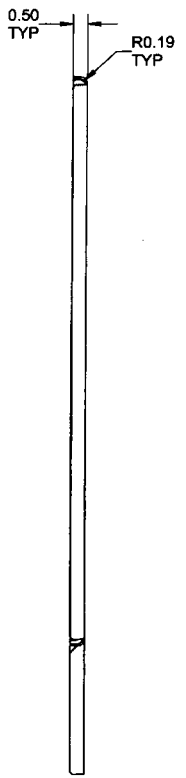
D4463-1 TANK TOP

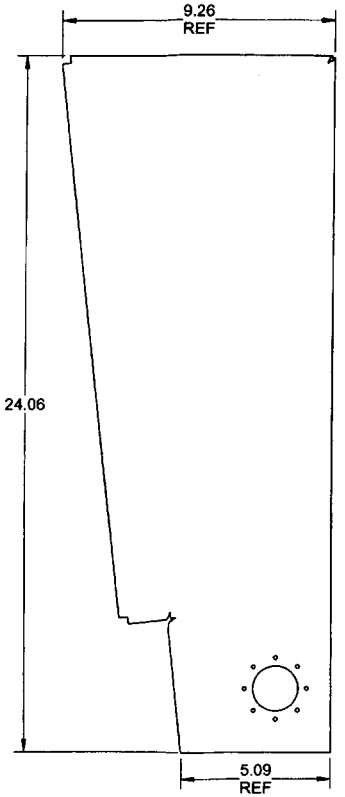
RELEASED
2014 -06- 11

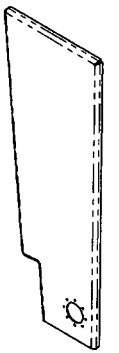
NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.70 lbs

APPROVED		
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	ML	
CHECKED	AP	DRAWING NO. D4463 REV. D
MFG. APPR.	JLM	SHEET 2 OF 14
APPROVED	MP	TITLE AUX TANK SCALE NTS
DE APPR.	DS	
DATE	14.05.13	

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RELEASED
2014 -06- 11

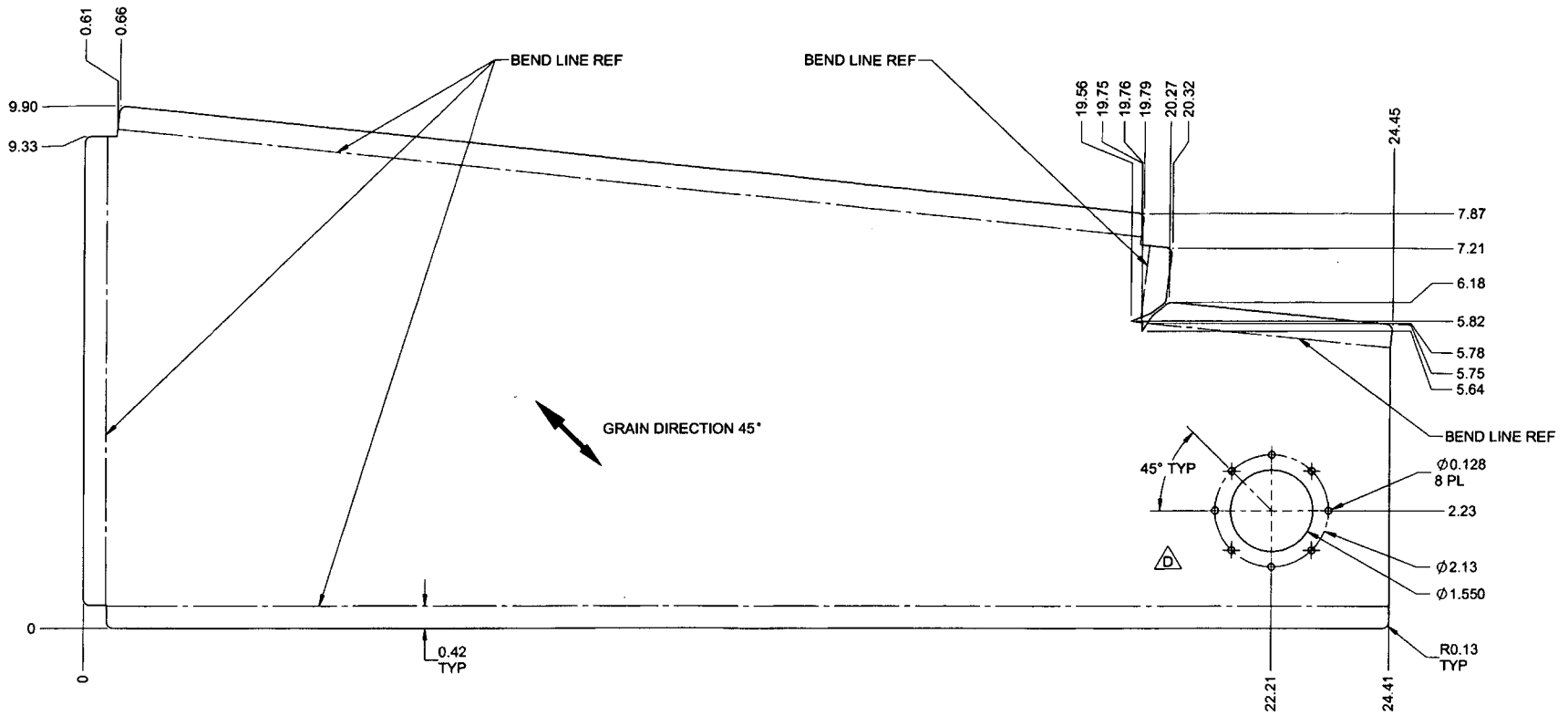
D4463-3 TANK AFT END

NOTES:
1) MATERIAL: MADE FROM D4463-3F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.24 lbs

APPROVED

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	ML	
CHECKED	AP	DRAWING NO. D4463 REV. D
MFG. APPR.	JLM	SHEET 3 OF 14
APPROVED	MP	TITLE AUX TANK SCALE NTS
DE APPR.	DS	
DATE 14.05.13		

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D4463-3F FLAT PATTERN

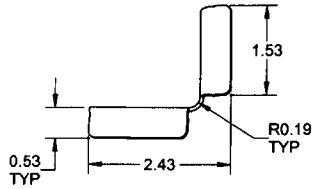
RELEASED
2014 -06- 11

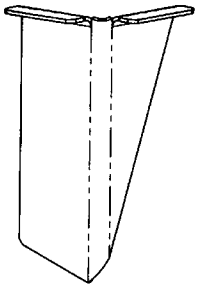
NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.24 lbs

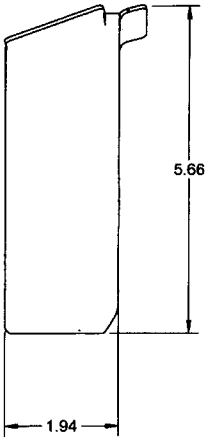
APPROVED

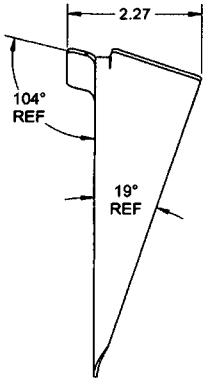
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DRAWN	ML	HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	DRAWING NO. D4463 REV. D
MFG. APPR.	JLM	SHEET 4 OF 14
APPROVED	MP	TITLE AUX TANK SCALE NTS
DE APPR.	DS	
DATE	14.05.13	

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D4463-5 TANK UPPER CUT OUT

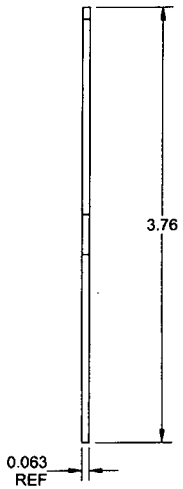
RELEASED
2014 -06- 11

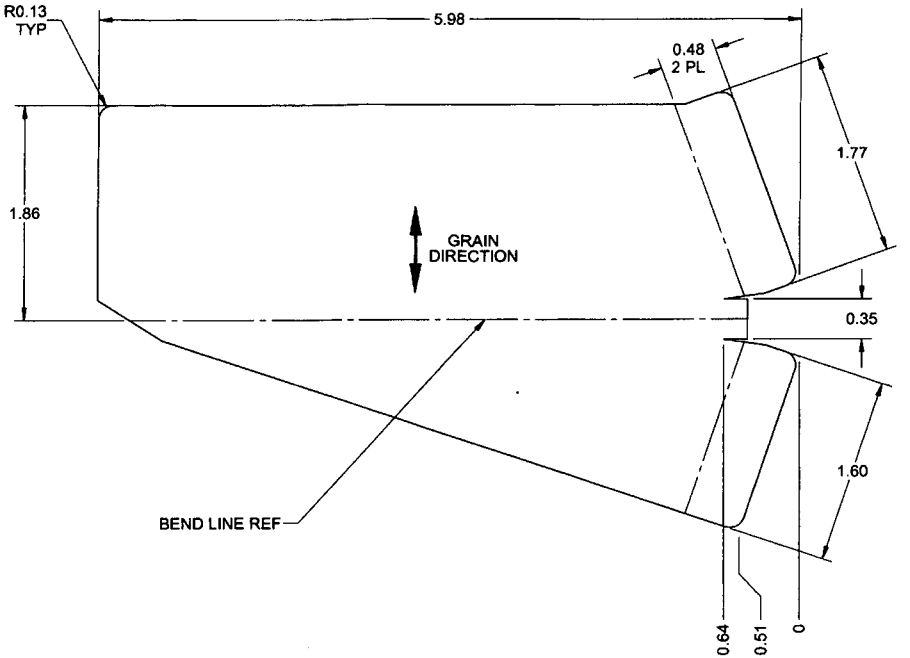
NOTES:
1) MATERIAL: MADE FROM D4463-5F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.10 lbs

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DESIGN	ML	DART AEROSPACE LTD
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	DRAWING NO. D4463 REV. D
MFG. APPR.	JLM	SHEET 5 OF 14
APPROVED	MP	TITLE AUX TANK SCALE NTS
DE APPR.	DS	
DATE	14.05.13	

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D4463-5F FLAT PATTERN

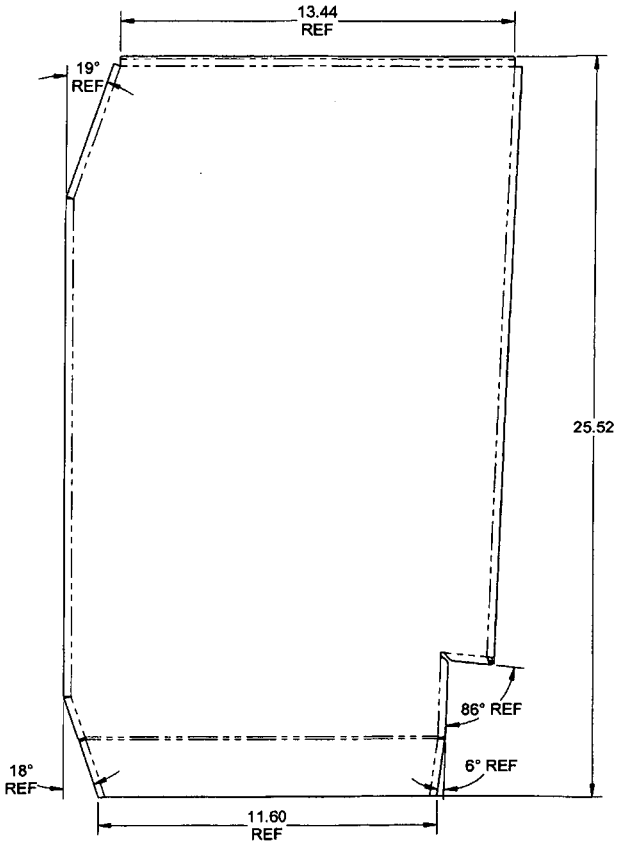
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2014 -06- 11
D

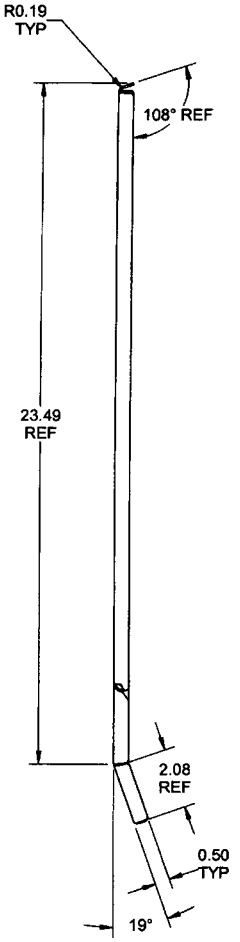
NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.10 lbs
8) ALL NON DIMENSIONED FEATURES PER DRAWING FILE "D4463-5F-D.DXF"

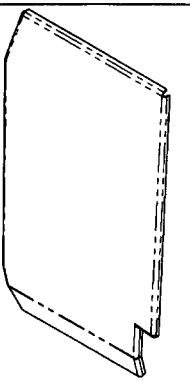
APPROVED

DESIGN	ML	DART AEROSPACE LTD
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	DRAWING NO. D4463 REV. D
MFG. APPR.	JLM	SHEET 6 OF 14
APPROVED	MP	TITLE AUX TANK SCALE NTS
DE APPR.	DS	
DATE	14.05.13	

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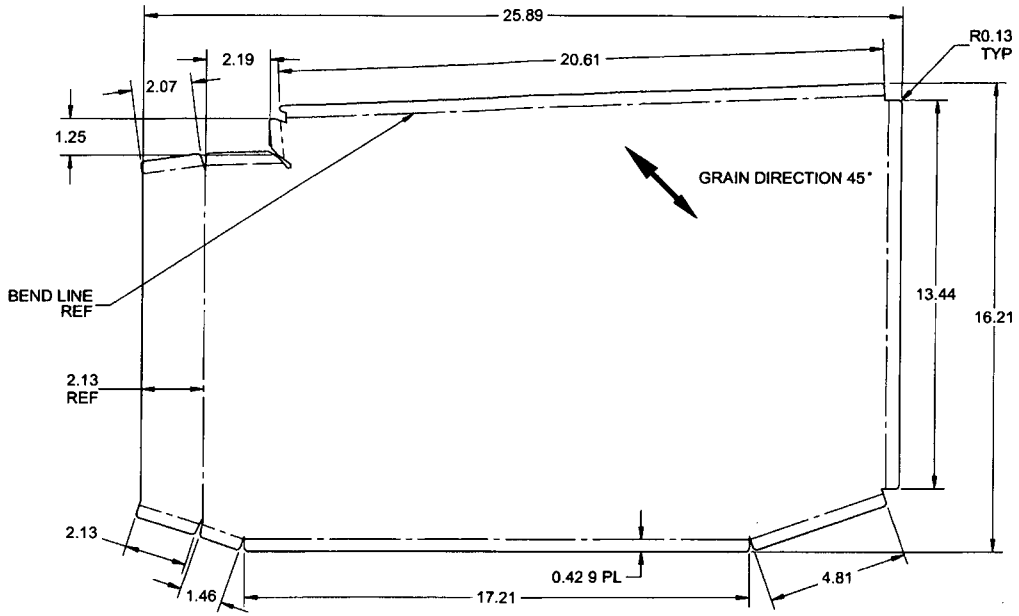
D4463-7 TANK FORWARD END

NOTES:
1) MATERIAL: MADE FROM D4463-7F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.41 lbs

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DESIGN	ML	DART AEROSPACE LTD
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	DRAWING NO. D4463 REV. D
MFG. APPR.	JLM	SHEET 7 OF 14
APPROVED	MP	TITLE AUX TANK
DE APPR.	DS	SCALE NTS
DATE	14.05.13	

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D4463-7F FLAT PATTERN

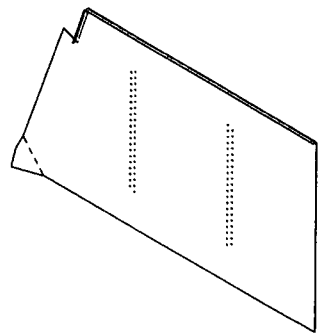
RELEASED
2014-06-11

NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.41 lbs
8) ALL NON DIMENSIONED FEATURES PER DRAWING FILE "D4463-7F-D.DXF"

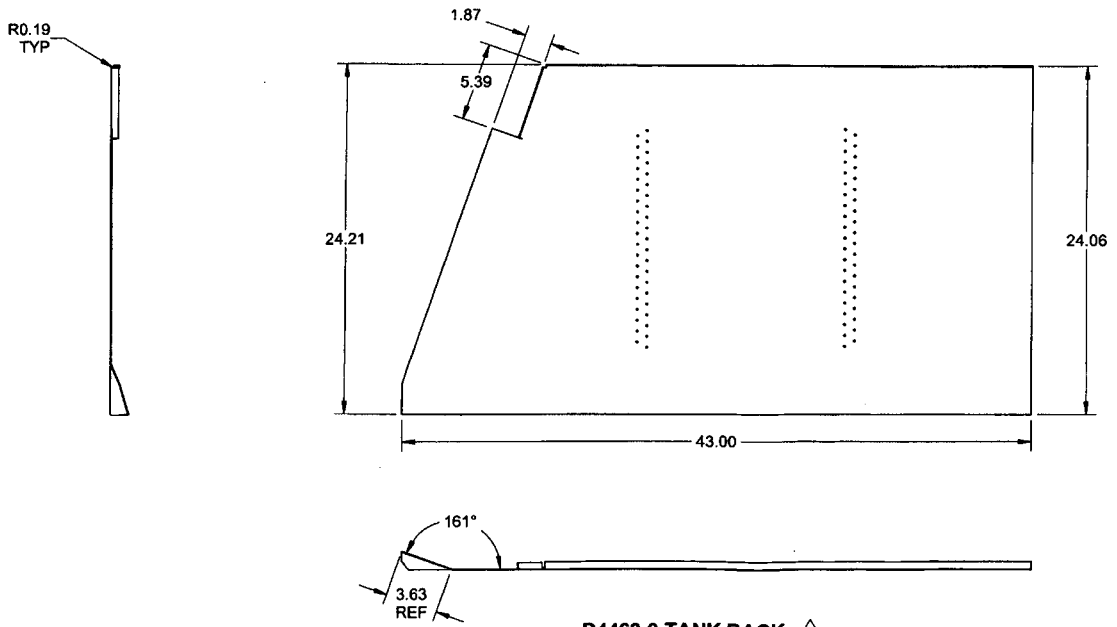
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DESIGN	ML	DART AEROSPACE LTD
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	DRAWING NO. D4463 REV. D
MFG. APPR.	JLM	SHEET 8 OF 14
APPROVED	MP	TITLE AUX TANK SCALE NTS
DE APPR.	DS	
DATE	14.05.13	

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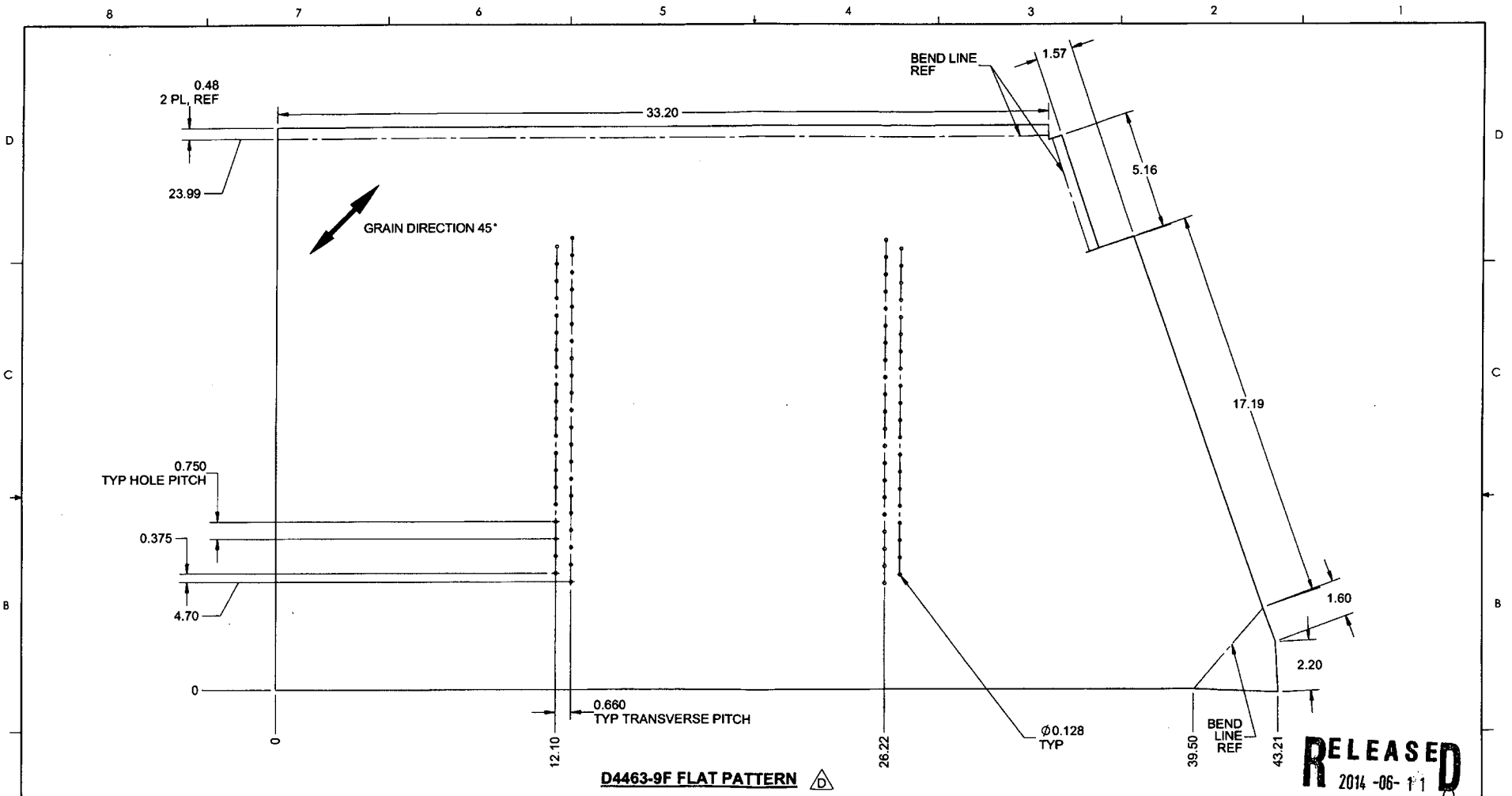
D4463-9 TANK BACK (D)

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2014 -06- 11

NOTES:
1) MATERIAL: MADE FROM D4463-9F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.68 lbs

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DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AP	DRAWING NO. D4463	REV. D
MFG. APPR.	JLM		SHEET 9 OF 14
APPROVED	MP	TITLE AUX TANK	SCALE NTS
DE APPR.	DS		
DATE	14.05.13		

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D4463-9F FLAT PATTERN △D

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2014 -06- 11

NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.68 lbs
8) ALL NON DIMENSIONED FEATURES PER DRAWING FILE "D4463-9F-D.DXF"

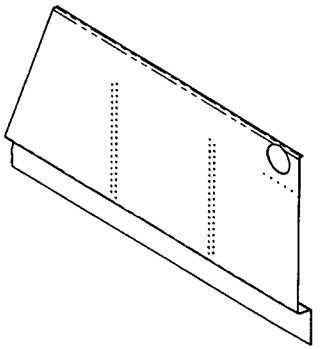
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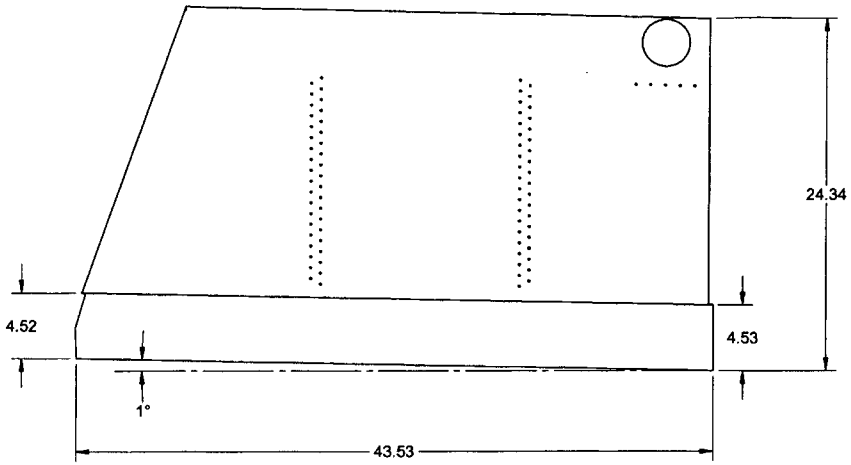
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DRAWN	ML
CHECKED	AP
MFG. APPR.	JLM
APPROVED	MP
DE APPR.	DS
DATE	14.05.13

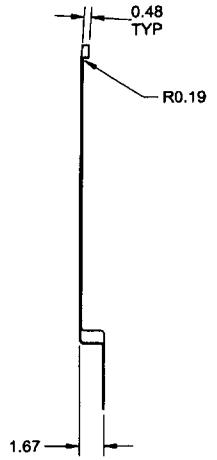
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4463 REV. D
SHEET 10 OF 14
TITLE AUX TANK
SCALE NTS

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2014 -06- 11
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D4463-11 TANK FRONT △D

NOTES:
1) MATERIAL: MADE FROM D4463-11F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 6.39 lbs

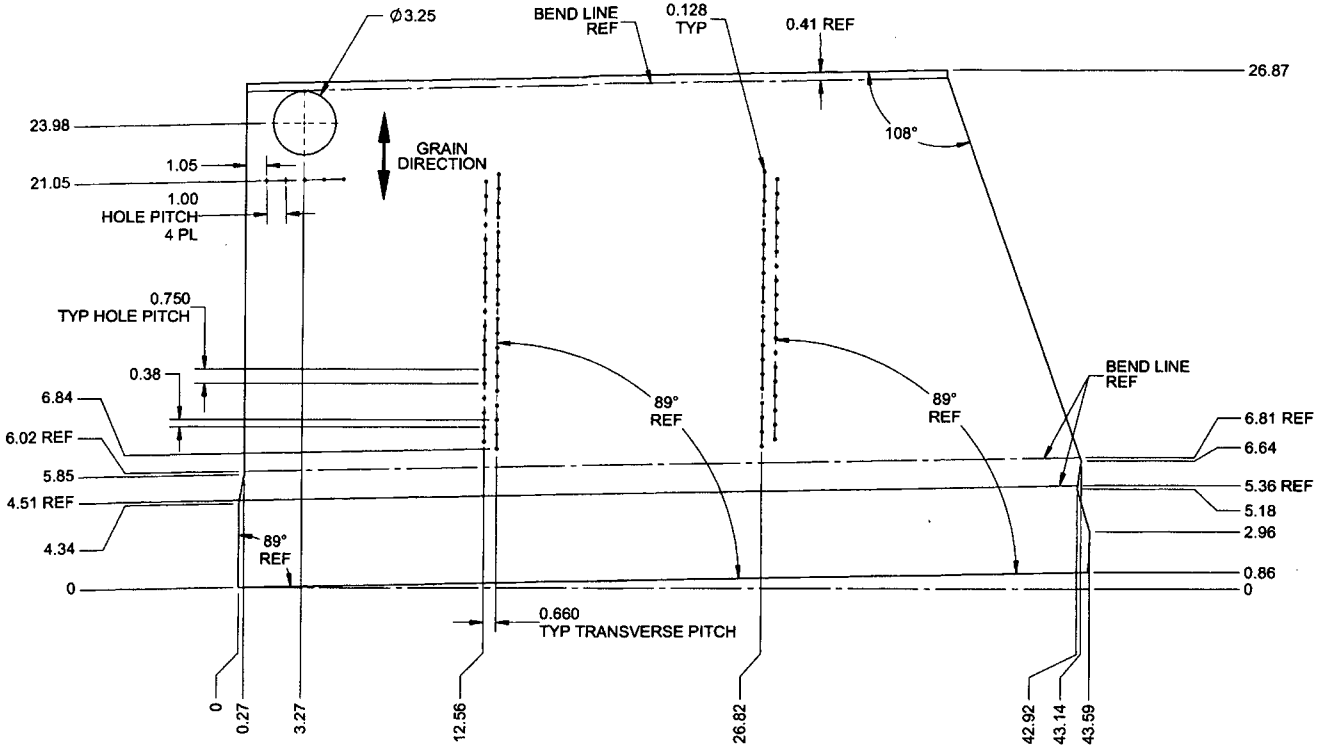
APPROVED

DESIGN	ML
DRAWN	ML
CHECKED	AP
MFG. APPR.	JLM
APPROVED	MP
DE APPR.	DS
DATE	14.05.13

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4463 REV. D
SHEET 11 OF 14
TITLE AUX TANK SCALE NTS

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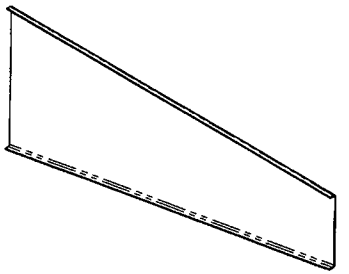
NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 6.39 lbs
8) ALL NON DIMENSIONED FEATURES PER DRAWING FILE "D4463-11F-D.DXF"

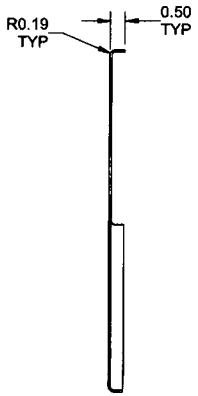
D4463-11F FLAT PATTERN (D)

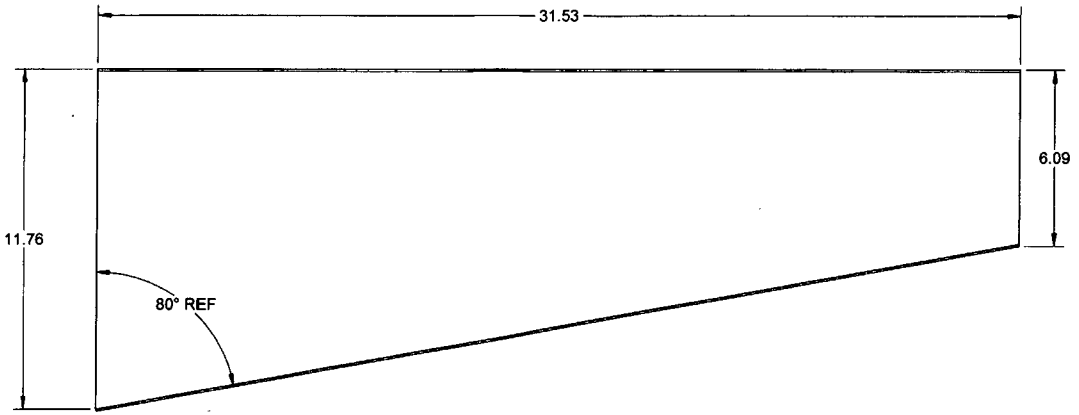
APPROVED

DESIGN	ML	DART AEROSPACE LTD
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	DRAWING NO. D4463 REV. D
MFG. APPR.	JLM	SHEET 12 OF 14
APPROVED	MP	TITLE AUX TANK
DE APPR.	DS	SCALE NTS
DATE	14.05.13	

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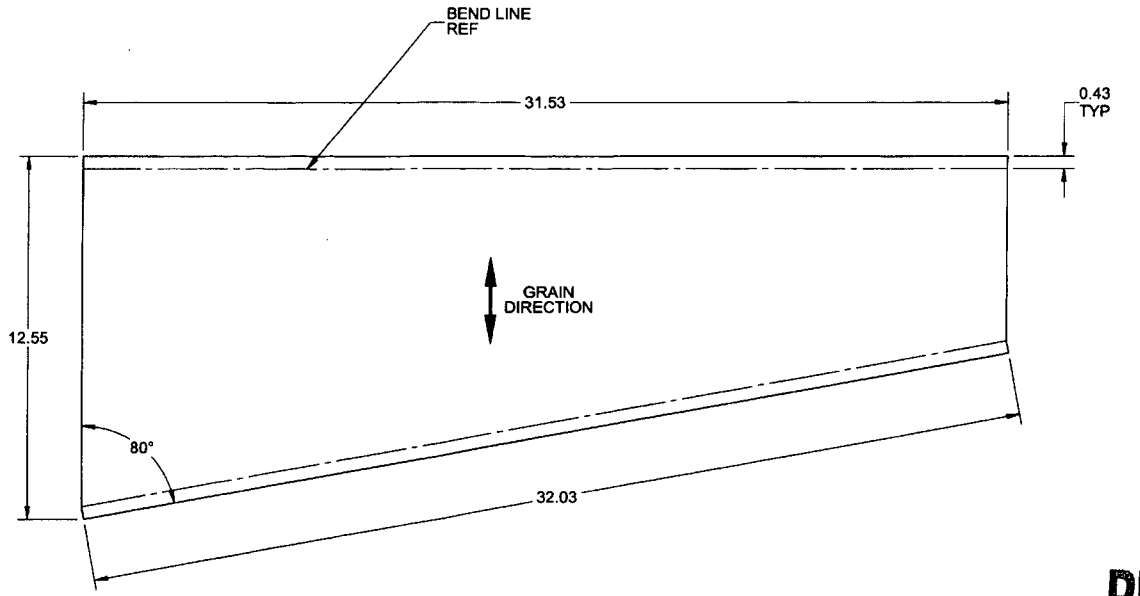
D4463-13 TANK BOTTOM

NOTES:
1) MATERIAL: MADE FROM D4463-13F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.88 lbs

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DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	ML	
CHECKED	AP	DRAWING NO. D4463 — REV. D
MFG. APPR.	JLM	SHEET 13 OF 14
APPROVED	MP	TITLE AUX TANK — SCALE NTS
DE APPR.	DS	
DATE	14.05.13	

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D4463-13F FLAT PATTERN

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2014 -06- 11

NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.88 lbs

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DESIGN	ML	DART AEROSPACE LTD
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	DRAWING NO. D4463 REV. D
MFG. APPR.	JLM	SHEET 14 OF 14
APPROVED	MP	TITLE AUX TANK SCALE NTS
DE APPR.	DS	
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